

Date: Tuesday, 15/08/2006 7:53:21 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HEATER BRACKET		
Job Number	: 28129						
Estimate Number	: 12159						
P.O. Number	: N/A			Part Number	: D2002003		
This Issue	: 15/08/2006	S.O. No.	: N/A	Drawing Number	: D2002-003 REV C		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 10/08/2006	Type	: SMALL /MED FAB	Drawing Revision	: C		
Previous Run	:			Material	: N/A		
Written By	:			Due Date	: 10/09/2006	Qty:	4
Checked & Approved By	:			Um:	Each		
Comment	: Est. B 99.05.21 Re-format, Made in house DM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 
	Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s) 2024-T3 .063 sheet Material: 2024-T3, 0.063" Thick Batch <u>M2024T3S063</u> 9054	 SAP 06:08:16 4
2.0	WATER JET	FLOW WATER JET Dwg <u>C</u> Prog <u>C</u> 
	Comment: FLOW WATER JET	SAP 06:08:16 (4)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAP 06:08:16 (5)
4.0	QC8	SECOND CHECK 
	Comment: SECOND CHECK	J 06:08:20 (6)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Countersink holes as per Dwg D2002-003	F 06.08.30
	Deburr	
	Form as per Dwg D2002-003	S 06/08/31

S.1. QCS Inspect work.

✓ 260831 (4)

SB Dec/08/31 4

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER BRACKET

Job Number: 28129

Part Number: D2002003

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI-005 4.1

SAP

06/08/02

(4)

7.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PG

PURCHASING



Comment: PURCHASING

Issue P/Q.

Powder Coat Black Crinkle (Ref. 4.3.5.3)as per QSI 005 4.3

a.m.

06-09-02

(4)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/08 (4)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198

06/08 (4)

(4) →

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/02 (4)

Job Completion



W 06/09/02

→

Date: Thursday, 10/08/2006 10:01:37 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEATER BRACKET		
Job Number	: 28129	Part Number	: D2002003		
Estimate Number	: 12159	Drawing Number	: D2002-003 REV C		
P.O. Number	:	Project Number	: N/A		
This Issue	: 10/08/2006	S.O. No.	:		
Prsh Rev.	: NC	Type	: SMALL /MED FAB		
First Issue	: / /	Material	:		
Previous Run	:	Drawing Revision	: C		
Written By	:	Due Date	: 10/09/2006 Qty: 4 Um: Each		
Checked & Approved By	: <u>L</u>				
Comment	: Est. B 99.05.21 Re-format, Made in house DM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M2024T3S063	2024-T3 .063 sheet		
		Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s) 2024-T3 .063 sheet Material: 2024-T3, 0.063" Thick Batch		<i>W. L. Hargrave</i>
2.0	SHEAR	SHEAR		
		Comment: SHEAR Cut blanks: 9.350" x 5.930" Grain Along 5.930"		<i>W. L. Hargrave</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2002-003		<i>D</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Countersink holes as per Dwg D2002-003		<i>→</i>
		Deburr		<i>→</i>
		Form as per Dwg D2002-003		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-08-31	S.O	Need QC 5 after delav: forming. Perm. Change	R	06-09-28		AB 05/09/22	06-08-31
06-08-31	F.O	Should be QC 3 for stockline. Perm. Change	R	06-09-22		AB 05/09/22	06-08-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-16 SAD	Z	Scrap 3 pieces on the waterjet the hole of those pieces were not to big because of the Drawing "Program" for the waterjet	AB 05/09/22	Scrap and destroy	06-05-16 SAD	06-08-20	AB 05/09/22	06-08-20

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER BRACKET

Job Number: 28129

Part Number: D2002003

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
8.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: _____ Powder Coat Black Crinkle (Ref. 4.3.5.3)as per QSI 005 4.3		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
11.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21		

Job Completion



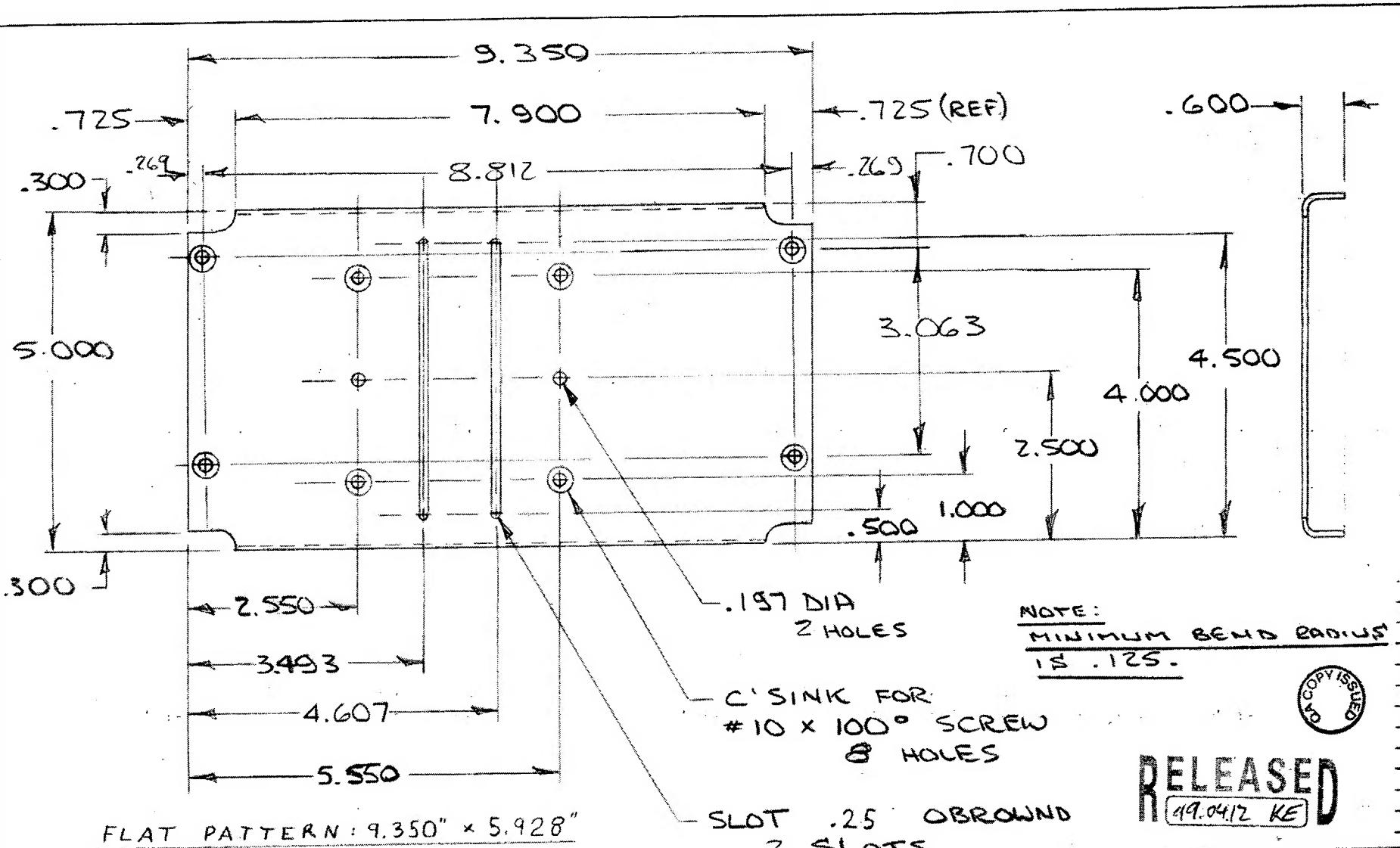
✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



C	B	A	REVISION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED
KE	JB	JB	DRAWN	GENERAL
21/11/10	91.9-10		APPROVED	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 17/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5-.7742 5. HOLES PER AND 1087
REDRAWN TRANSFER TO SMALL SHEET	ADDED HTC HOLES		DESCRIPTION OF CHANGE	1. TOLERANCES — .001 ± .030 2. ANGLES ± 1° 3. PARALLELISM .00025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005
				REPORT ALL DISCREPANCIES — DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC/VENDOR	
CONTRACT NO.		DRAWN		DESIGN		TITLE		CODE		REV	
D2002-003 BRACKET		91/9/10		DART		DART AERO ACCESSORIES INC.		YU		D2002-003	
BASIC CODE		DIA DASH NO. PINHEAD REAR SIDE PINHEAD FA SIDE		LENGTH DASH NO. W-W SPOTWELD		DRAWN NO.		Dwg No.		A	
D-COUNTERSINK CUTTING OF SHEETS		BASIC CODES		CODE		CLIENT		SCALE		SHT	
D2002-003		BRACKET		2024-T3 X .063		1:2		1 OF 1		C	

2 1

DART AEROSPACE LTD	Work Order:	28129
Description:	Part Number:	D2602 003
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>SAM</u>	Audited by:	<u>/</u>	Prototype Approval:	
Date:	<u>06.08.16</u>	Date:	<u>16.08.20</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	